



## **TAC-157 & ART-83 1996-2004 TOYOTA TACOMA MID FRAME SECTION AT FORWARD REAR SPRING MOUNT**

**IMPORTANT: Read and understand the General Instructions  
Before Installing SafeTCap® Frame Repair Kits**

### **Installation Instructions**

- 1)** Leave the truck bed on – This helps keep the frame straight. Check the gap between the cab and bed during the install to ensure nothing has shifted.
- 2)** Jack up the rear of the vehicle – Support it with jack stands about 7" in front of the rear cab mount on each side. Also place stands under the rear of the frame. Let the rear axle hang free.
- 3)** Remove the fuel tank – This gives you access to the spring mount.
- 4)** Remove the forward spring bolt and pry the spring from the mount.
- 5)** Measure the distance from the forward spring mount bolt center to the rear spring shackle mount bolt center. This is important for kit positioning.
- 6)** Cut off the forward rear spring mount (TAC-083 install only). Cut as close to the mount as possible without damaging it.
- 7)** Cut off the spring mount and any rusted lower frame section – but do not remove more than half of the frame's lower portion. Slide the SafeTCap® kit on and mark its outline to avoid cutting too much.
- 8)** Clean the original frame surface with a grinder.
- 9)** Slide the SafeTCap® kit onto the frame, align it using your measurements, clamp it in place, and close any gaps.
- 10)** Tack weld the kit to the frame – Re-check your spring mount measurements.
- 11)** Weld the kit fully to the frame.
- 12)** Reinstall the leaf spring and coat the frame with rust-inhibiting primer or undercoating.
- 13)** Reinstall the fuel tank and rear tires, lower the vehicle, and check the cab-to-bed gap one last time.